



# BETASEAL™ Express+

60-minute minimum drive away down to 0°F

## Improved advanced cure adhesive formula

- Exclusive RPM adhesive technology
- High modulus, non-conductive
- Easy to dispense
- Short tail
- Outstanding decking
- Easy-to-tool
- 8 – 10 minute working time
- Value-priced adhesive system
- New BETAPRIME™ CLEAR Advanced compatible – G-EZKit only
- Single component – 600 ml sausage, 310 ml cartridge or part of a BETASEAL™ G-EZKit




Made in the USA




BetasealARG.com

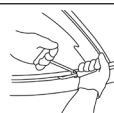
# Windshield Installation Instructions

**1**  **Wear appropriate safety equipment**


- Protect yourself
- Wear safety equipment, such as work gloves, nitrile chemical-resistant gloves, safety glasses, work apron or other protection required by your company

**2**  **Inspect replacement glass**

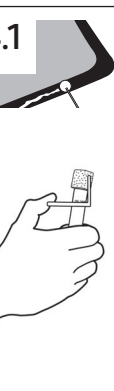
- Spray glass bonding surface and vision area with BETACLEAN™ GC-800 Glass and Surface Cleaner and wipe glass clean with a lint-free paper towel
- Inspect replacement glass for defects, damage or signs of contamination
- Verify primer and adhesives are within use-by dates

**3**  **Cut out the glass**

- Protect the customer's vehicle
- Remove all hardware and reveal moldings
- Cut out from the windshield using your preferred method

**4**  **Prepare the glass**

- Many contaminants are difficult to detect and remove
- Spray glass with BETACLEAN™ GC-800 Glass and Surface Cleaner
- Use a BETACLEAN™ Easy-Go Cleaning Sponge or an abrasive pad to abrade the surface
  - This is a mechanical abrasion step, make sure to use some pressure
  - Ensure the entire bonding surface is treated
- While the surface is still wet, wipe surface with a clean paper towel
- Spray glass again with BETACLEAN™ GC-800
  - If the glass cleaner de-wets, repeat steps a through d
  - If the glass cleaner does not de-wet, proceed to glass priming step

**4.1**  **4.1a Glass priming instructions using BETAPRIME™ 5504G All-in-One Primer**

- Check the expiration date on the container
- If using BETAPRIME™ 5504G All-in-One Primer in bottle, open cap and use the loose cap to pry up the inner seal in a circular motion containing the inner seal in the cap or by pulling gently on the grab ring in the inner seal
  - If using BETAPRIME™ 5504G SA stick, slide breaker bar over date code on the tube with the prongs facing the foam. While holding the applicator with the foam facing up, press down on the breaker bar with the thumb until the inner container breaks releasing the contents. Point the foam head down toward surface to be primed. Allow the primer to saturate the foam head. Gently squeezing the tube will allow the foam head to saturate faster. Apply light pressure to the foam head (too much will damage the foam during application). Slowly draw the applicator around the surface to be primed to get an even glossy primer film. Apply in one even wet coat moving the stick in the same direction. Some applications on or next to rough encapsulations or moldings may damage the foam head. To avoid this, use caution and limit contact with these areas. Additionally, using a dauber to apply primer from a bottle may be advisable.

#### For any fritted glass (internal or external):

- Apply BETAPRIME™ 5504G All-in-One Primer with a clean wool dauber or primer stick in one, even, wet coat, moving in the same direction
- Allow the primer to dry for 2 minutes at 20° F (-7°C) and above. From 20° F (-7°C) down to 0° F (-18°C), allow the primer to dry for 6 minutes.
- Surfaces primed with BETAPRIME™ 5504G are good for 24 hours after priming. If not used within 24 hours, apply another coat of BETAPRIME™ 5504G to reactivate.

#### For glass without any frit:


- Apply BETAPRIME™ 5504G All-in-One Primer with a clean wool dauber or primer stick in one, even, wet coat, moving in the same direction
- Allow the primer to dry for 2 minutes at 20° F (-7°C) and above. From 20° F (-7°C) down to 0° F (-18°C), allow the primer to dry for 6 minutes.
- Apply a second coat of BETAPRIME™ 5504G and allow to dry for 2 minutes at 20° F (-7°C) and above. From 20° F (-7°C) down to 0° F (-18°C), allow primer to dry for 6 minutes. When using BETAPRIME™ 5504G SA primer stick on clear glass, two sticks may be required for proper application.

**WARNING:** BETASEAL™ Xpress30 is not compatible with BETAPRIME™ CLEAR Advanced


#### 4.1b Glass priming instructions using BETAPRIME™ CLEAR Advanced SA (Express+ only)

- Point pad of BETAPRIME™ CLEAR Advanced SA stick 1-Step Glass/Frit Primer toward the surface to be primed and pinch tube between thumb and forefinger to break internal vial, releasing the primer
- Allow the pad to saturate; it is not necessary to squeeze the tube
- Slowly draw the applicator twice around the surface to be primed to get an even glossy primer film (do not wipe off)
- Wait 2 minutes for the primer to dry before installing glass in temperatures down to 0° F (-18°C)
- If glass is not installed within 24 hours of original priming, reprime the glass with BETAPRIME™ CLEAR Advanced primer; do not reprime more than once
- When priming glass with BETAPRIME™ CLEAR Advanced primer in temperatures from 0° F (-17.8°C) to 40° F (4.4°C), the glass should be cleaned at a temperature at or above 40° F (4.4°C) and stored in a manner that will keep it clean and contaminant free


**Note:** On clear glass without any frit, apply two coats of BETAPRIME™ 5504G, allowing each coat to dry

**4.2**  **Prepare encapsulation or PAAS**

- Clean encapsulation or PAAS bead with BETACLEAN™ GC-800 Glass and Surface Cleaner and a clean, lint-free paper towel
- "Wet scrub" the encapsulation with an abrasive pad and BETACLEAN™ GC-800, then clean again with BETACLEAN™ GC-800 and allow to dry completely  
**Note: Lightly abrade if bonding to PAAS**
- Apply BETAPRIME™ 5504G All-in-One Primer to the encapsulation or PAAS surface with dauber
- Apply BETAPRIME™ 5504G to any molding surface that contacts new urethane to promote adhesion
- Allow primer to dry for 2 minutes at 20° F (-7°C) and above and from 20° F (-7°C) down to 0° F (-18°C) allow primer to dry for 6 minutes
- Replace inner seal and cap on bottle immediately

**5**  **Trim back the urethane**

- Clean any dirt and debris from around the existing urethane with BETACLEAN™ GC-800 Glass and Surface Cleaner or water and a clean towel
- Trim the urethane, leaving a 1 mm to 2 mm base of original equipment urethane on the pinch weld
- Take care not to damage the vehicle paint or pinch weld
- Any areas of trimmed urethane that require additional cleaning should be carefully wiped with BETACLEAN™ GC-800 or water and a clean towel


**6**  **For priming any areas of bare metal (large or small, including scratches):**

- Check the expiration date on the container
- Open the bottle of BETAPRIME™ 5504G All-in-One Primer carefully and insert a clean, unused dauber; to avoid spilling, never pour liquid on dauber
- Apply first coat of BETAPRIME™ 5504G with a clean wool dauber on any exposed bare metal
- Allow primer to dry for 2 minutes at 20° F (-7°C) and above and from 20° F (-7°C) down to 0° F (-18°C) allow primer to dry for 6 minutes
- Apply second coat of BETAPRIME™ 5504G with a clean wool dauber on any exposed bare metal and allow to dry
- Replace inner seal and cap on bottle immediately


**Warning:** Do not reinsert (double dip) the dauber into the primer bottle if it has touched the body of the vehicle. This could contaminate the remaining primer in the bottle.

#### For priming painted bonding surfaces:


- Check the expiration date on the container
- Open the bottle of BETAPRIME™ 5504G All-in-One Primer carefully and insert a clean, unused dauber; to avoid spilling, never pour liquid on dauber
- Apply one coat of BETAPRIME™ 5504G with a clean wool dauber on any exposed bare metal
- Allow primer to dry for 2 minutes at 20° F (-7°C) and above and from 20° F (-7°C) down to 0° F (-18°C) allow primer to dry for 6 minutes
- Replace inner seal and cap on bottle immediately

**7**  **Apply BETASEAL™ Adhesive (Choose either glass or pinchweld application)**


- Hold the applicator in a vertical position 90° to the glass and dispense the adhesive with a continuous motion in a uniform "V" shaped bead
- Apply adhesive to the glass on top of the bond line, matching the location of the original adhesive bead on the glass or apply adhesive to the pinchweld perimeter directly on top of the freshly cut original equipment urethane film
- Either application: Hold the applicator in a vertical position (90°) and dispense the adhesive with a continuous motion in a uniform "V" shaped bead
- Make sure bead is uniform and has no gaps; add material or gently tool joints, if necessary

**8**  **Install the glass**

- Carefully place the glass in the body opening
- Adjust glass to precise alignment
- Lightly press it into position

**9**  **Clean up**

- Clean any excess uncured urethane
- Clean the newly installed glass with BETACLEAN™ GC-800 Glass and Surface Cleaner
- Clean up any remaining debris or broken glass on seats, floor, door handles and/or dash console

**10**  **Recordkeeping**

- Attach master lot code sticker to paperwork or manually record primer and adhesive lot numbers
- Record D.O.T. number from glass part on sticker
- Release vehicle to customer after the appropriate drive-away time elapses